

Date: Tuesday, 12/05/2009 11:41:30 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L BASKET BASE
Job Number :	47904A		
Estimate Number :	11273		
P.O. Number :		Part Number :	D2252041
This Issue :	12/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2252 REV.G
First Issue :	1/1	Project Number :	N/A
Previous Run :	45976A	Drawing Revision :	G
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	22/05/2009
Written By :		Qty:	1
Checked & Approved By :	<u>Julie Dawson</u>	Um:	Each
Comment :	Est Rev: I Revised as per Rev E 05-12-06 JLM Est Rev: J 08-09-09 revF as per dwg (ecn 08-522) DD verified by: EC Est Rev: K 09-03-18 Rev.G dwg ecn 09.532 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)
 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch:

E

N/A

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.
 Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

E N/A

OR PD 09-06-05

N/A

3.0	D22211	Rib
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Rib B47952

PD 09-06-05

4.0	D22351	Basket Rib
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Basket Rib B47953

PD 09-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:41:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 47904A

Part Number: D2252041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D22521	Frame
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Frame B46824

PD 09.06.05

6.0	D22529	Frame
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame B47844

PD 09.06.05

7.0	D225211	Frame
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame B47830

PD 09.06.05

8.0	D225213	Frame
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame B47839

PD 09.06.05

9.0	D225215	Frame
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame B47840

PD 09.06.05

10.0	D225217	Frame
------	---------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Frame B47841

PD 09.06.05

11.0	D22531	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2253	Gusset	B40894

PD 09.06.05

12.0	D2254	Gussett
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L BASKET BASE

Job Number: 47904A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2254

Lug

B39801

PD

09-06-05

13.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3

Bushing

B44365

PD

09-06-05

14.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581

Mounting Chancel

B47264

PD

09-06-05

15.0

D37481

Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Hinge Half

B34689

PD

09-06-05

✓

16.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal M111630

SAD 09-06-02

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required

A/R SS ROD Batch: M126160

PD

09-06-05

18.0

QC9

VISUAL WELDING INSPECTION





Comment: VISUAL WELDING INSPECTION

09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2252-041 PAR #: N/A Fault Category: Prod / Inv. Lrg NCR: (Yes) No DQA: A Date: 09/06/15
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/06/16

NCR: 47904A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/15	#15	Docking Assembly of D3748-1 major hinge Part was slightly cracked after drilling		SCRAP AND DO BY D3748-1 AND Replne B4 34689 Qty (4)	PD 09.06.03	S 07/06/16		S 07/06/16
	#17	RL Process						

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:41:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 47904A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation: Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/10 @

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST

2ND

START TIME:

10:30am

11:00am

OVEN TEMPERATURE:

400°F

400°F

FINISH TIME:

11:00am

11:30am

09-06-10

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/06/10 (1)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

47904

9/6/11

Q

S

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion



09.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

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 NO. 15527015
 14790717

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (2N A6-S). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JJB		
CHECKED	JJB	DRAWING NO.	REV. G
MFG. APPR.	JJB	D2252	SHEET 1 OF 6
APPROVED	JJB	TITLE	SCALE
DE APPR.	JJB	BASKET ASSEMBLY (206L)	NTS
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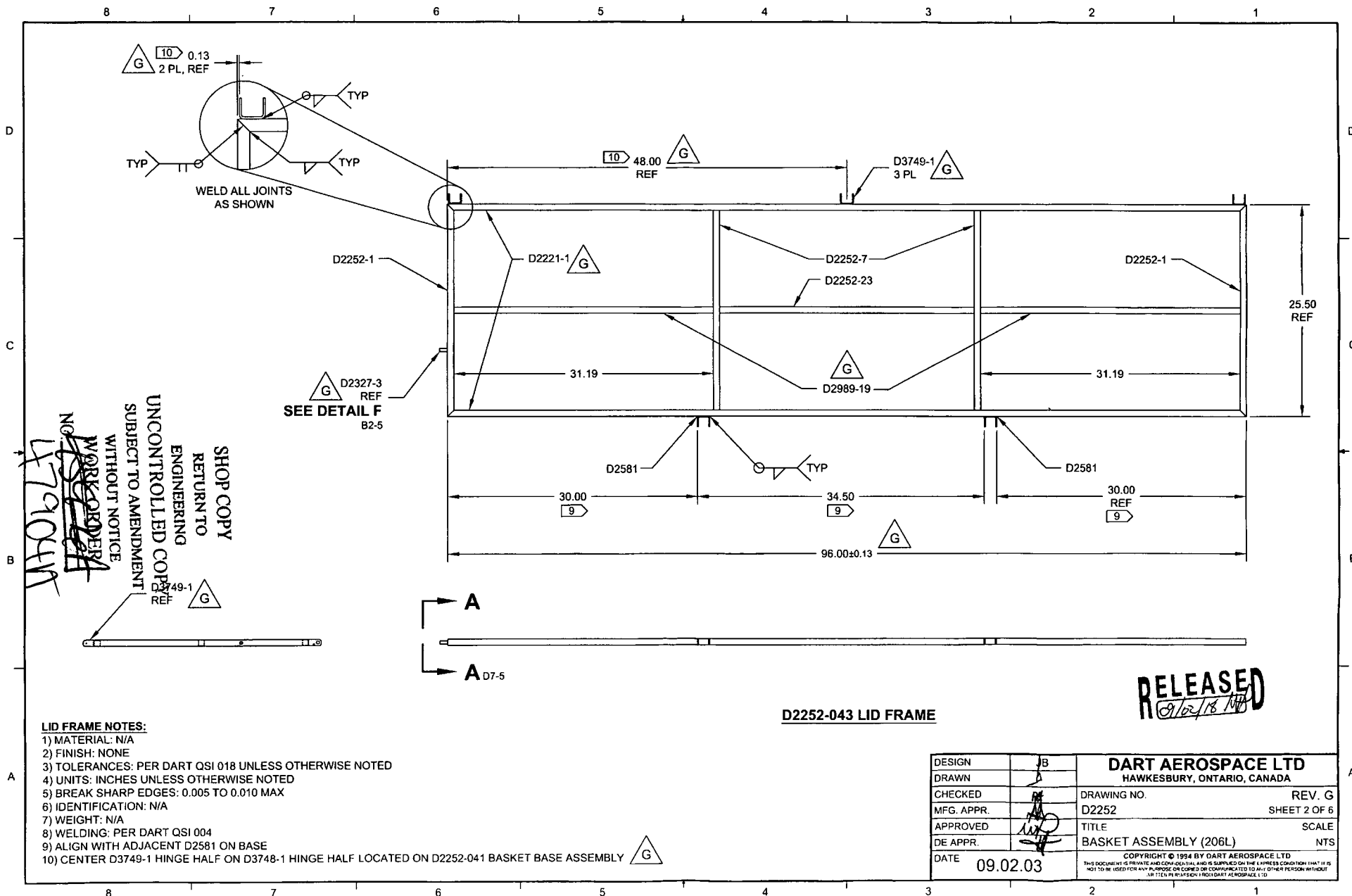
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



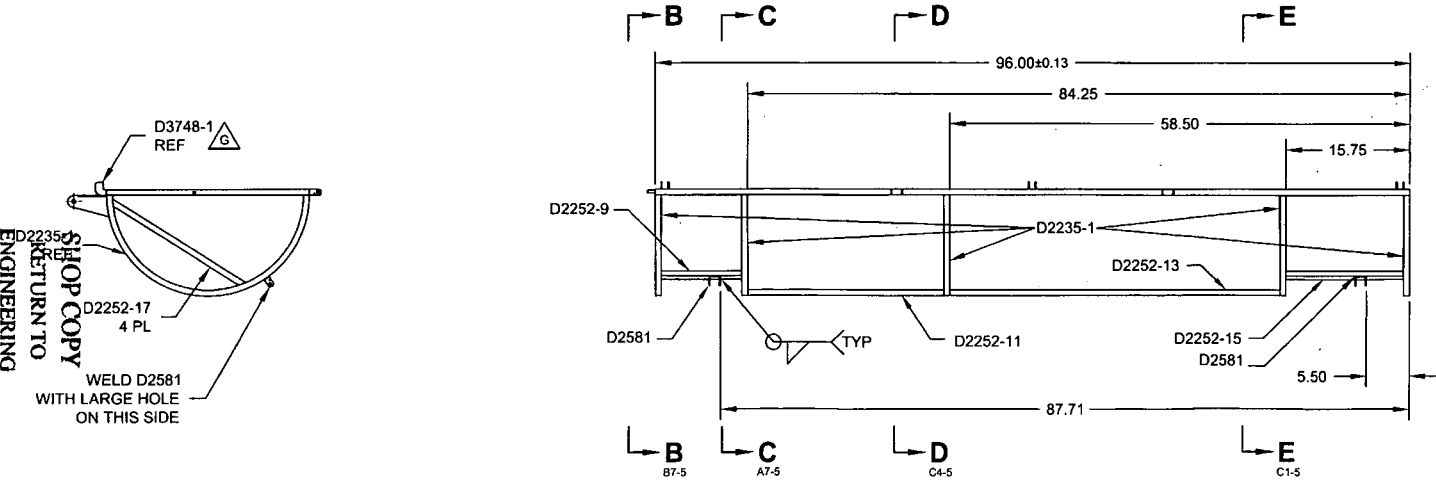
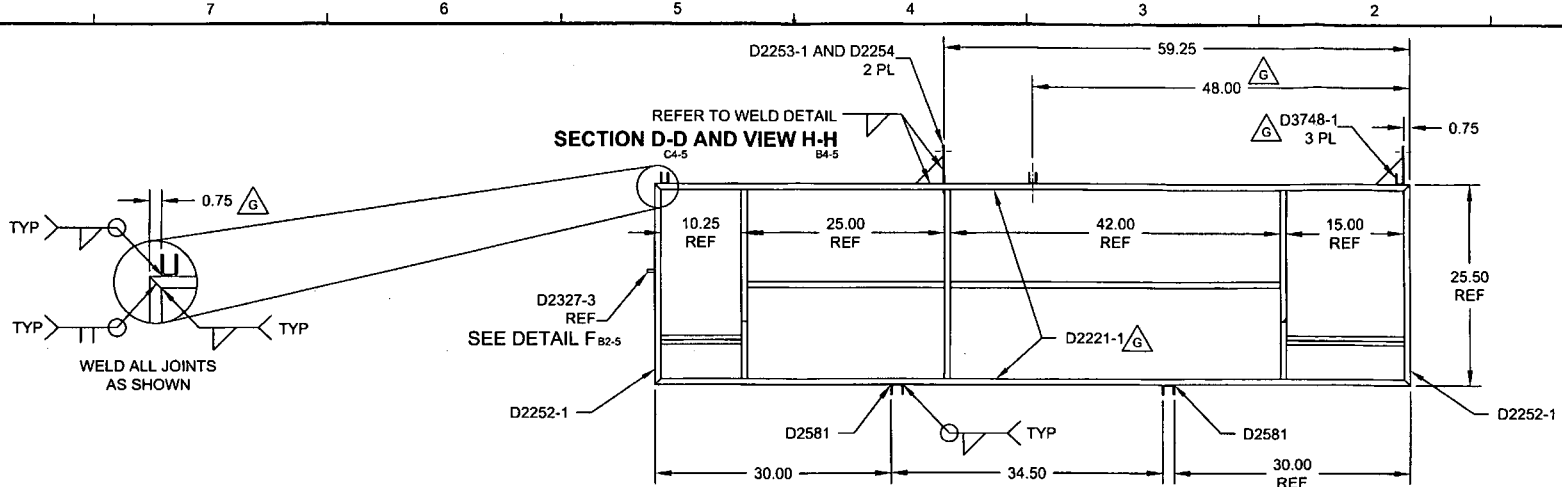
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NOTE: Date & initial all entries



D2252-041 BASE FRAME ASSEMBLY

RELEASED
09/02/03

- BASE FRAME NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

DESIGN	UB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
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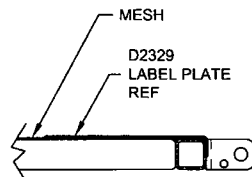
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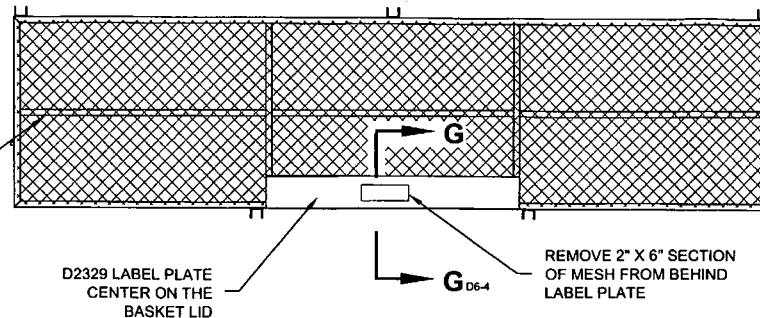
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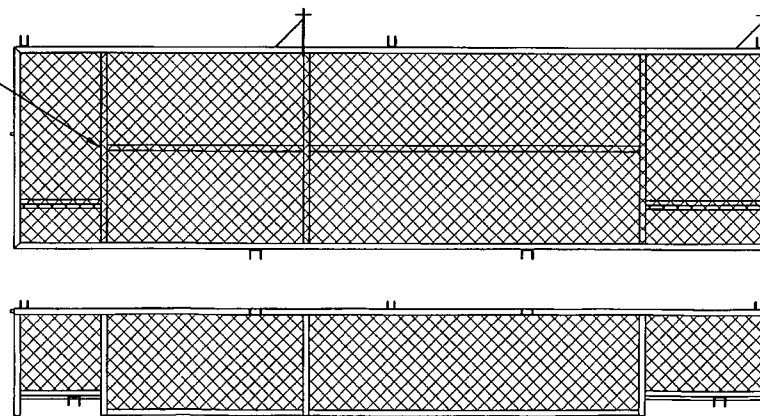


SECTION G-G C3-4
ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY

D3748-1
3 PL, REF

TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU
0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1

D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.02.03

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2252	REV. G SHEET 4 OF 6
TITLE BASKET ASSEMBLY (206L)	SCALE NTS

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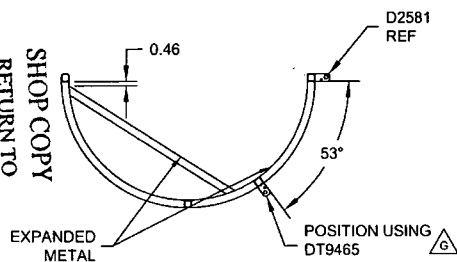
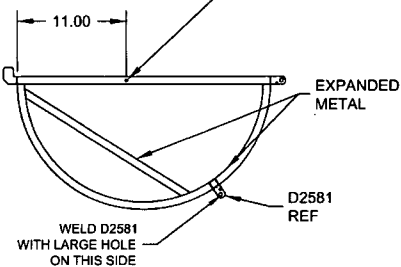
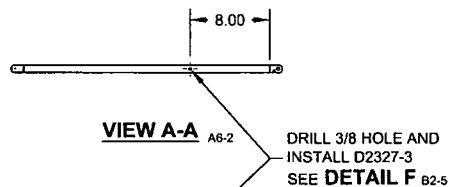
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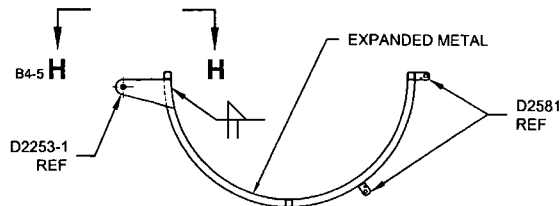
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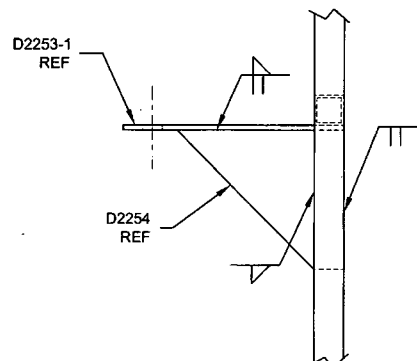
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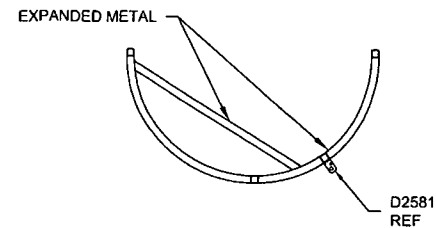
SECTION C-C A5-3



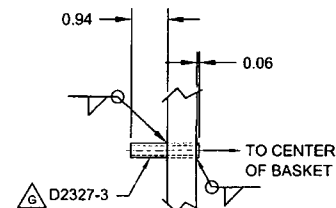
SECTION D-D D5-3



VIEW H-H D4-3 D5-5



SECTION E-E A2-3



DETAIL F C5-3
SPACER INSTALLATION C6-2

RELEASED
09/02/03

DESIGN	JE	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 5 OF 6
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8 7 6 5 4 3 2 1

NO WORK ORDER
1479047

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

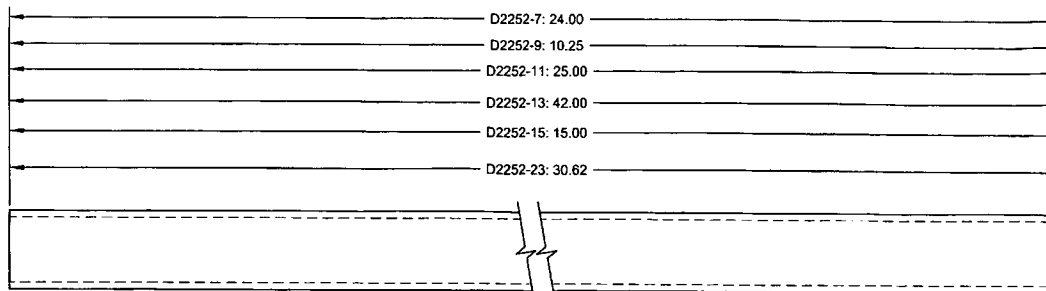
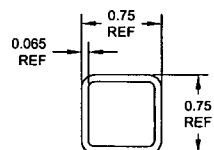
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

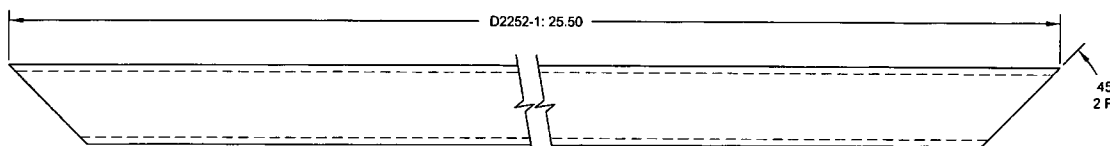
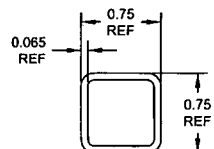
D



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME

C

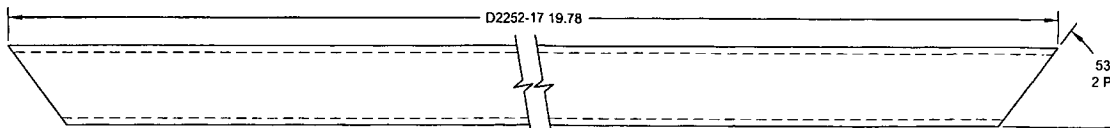
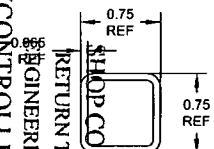
C



D2252-1 FRAME

B

B



D2252-17 FRAME

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 2/24/81

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 WITHOUT NOTICE

- NOTES:
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries